

Date: Thursday, 17/08/2006 3:17:26 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FUEL PURGE CANISTER INSTALLATION
Job Number : 28209	
Estimate Number : 12188	
P.O. Number : <i>N/A</i>	Part Number : D205706013
This Issue : 17/08/2006 S.O. No. : <i>N/A</i>	Drawing Number : <i>N/A</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : <i>N/A</i>
Previous Run : 26885	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 20/09/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D205-706-013CHG001	
2.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	D20014	Valve 1/4"
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 D2001-4 Valve Assembly <i>B23276</i> ✓	
4.0	D3262041	Fuel Purge Canister
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 D3262-041 Canister Assembly <i>B26416 X1V</i> ✓	
5.0	D32641	Bracket
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch <i>AP 06/08/28</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:17:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 28209

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D3264-1

Bracket

B23285 ✓ 2

6.0

D329710121

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose Ass'y

Qty Part Number Description Batch

1 D3297-1-0121 Hose Assembly

B26896 ✓ 1X ✓ B28226 3X ✓

7.0

D329710130

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose Ass'y

Qty Part Number Description Batch

1 D3297-1-0130 Hose Assembly

B26897 ✓ 1X ✓ B28227 3X ✓

8.0

D329730350

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose Ass'y

Qty Part Number Description Batch

1 D3297-3-0350 Hose Assembly

B26898 x1 ✓ B28228 3X ✓

9.0

D3298001

Tube Assembly 25"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3298-001 Tube Assembly

B23293 x3, B23294 x1 ✓ B28229 1X ✓ PAS 1001

10.0

D3298009

Tube Assembly 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3298-009 Tube Assembly

B27567 ✓

11.0

D32991

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3299-1

Fitting B23301 ✓ B06/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:17:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 28209

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting

B23012x2 ✓

13.0

D33011

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-1

Doubler

B23304 ✓

14.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard

B23305 ✓

15.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

B23306 ✓

16.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler

B26688x2 ✓

B28231

pos sets
2x

17.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt

M14526x2 M15205x14 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:17:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 28209

Part Number: D205706013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0	AN8146D	Plug
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

16369x1✓, 17677x3✓

19.0	AN8156D	Union-M-Flare
------	---------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN815-6D

Union

M17654✓

20.0	AN8336D	Elbow, Bulkhead-M-Flare
------	---------	-------------------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN833-6D

Elbow

M19620✓

21.0	AN9246D	Nut
------	---------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN924-6D

Nut

M17654 13 SORTISON BATCH

3?

22.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M100743✓

AB 06/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:17:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 28209

Part Number: D205706013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

23.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD10L

Washer

~~M101297~~ ⁴ M18235 ✓

24.0	AN960JD916	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN960JD916

Washer

² M100857 ✓

25.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

⁴ M100094 ✓

26.0	MS21919WDG9	Clamp
------	-------------	-------



Comment: Qty.: 5.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS21919WDG9

Clamp

⁵ M17137 ✓

27.0	MS21919WDG12	Clamp
------	--------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

1 MS21919WDG12

Clamp

¹ M12010 ✓

28.0	MS21919WDG16	Clamp
------	--------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

2 MS21919WDG16

Clamp

² M16322x4 ✓ M101925x4 ✓ AB 06/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:17:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 28209

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

MS2192042

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M18048 ✓

30.0

MS287786

Packing



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS28778-6

O-Ring

M17654 ✓

31.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 MS35489-11

Grommet

M16323 AB 06/08/28 ①

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD205-706-013

Location:

PPP Rev: B

AB 06/11/07 ①

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/08

Job Completion



u 06/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries